

12 AM 3

Work Order ID 143790

143790

Page 1

March 22, 2016 4:23:05 PM

Item ID: D205-706-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fuel Purge Canister

Start Date: 3/23/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Slt Date: 20160322 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN-D412-706

B

MW 1604-01

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

DAS
28
8
9-89DAS
28
9-89

APR 11 2016

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D205-706-013 CHG003

110

Pick Kit

0.00

110

Packaging

Memo

0.00

DAS
27
8
9-89DAS
27
9-89

MAR 31 2016

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

DAS
28
9-89

APR 11 2016

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Item ID: D205-706-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Purge Canister

Start Date: 3/23/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-706-013
Location : FG018**DAS**
28
988

APR 11 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS

APR 11 2016

MCS APR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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143790

D205-706-013

Start Date: 3/23/2016**Required Date:** 4/1/2016**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM IPP Rev:F 10.05.10 as per
chg002 DD verified :EC IPP Rev:G 12.12.07 as per IIN revB
DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2001-4		Manufactured	No			110	Each	7.0000	1	1			
D2001-4 Valve Assembly 1/4 inch													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST001		3							
					134329	3							
				ST012a		4							
					142185	4							
D3262-041		Manufactured	No			110	Each	1.0000	1	1			
D3262-041 Canister Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST492		1							
					137616	1							
D3264-1		Manufactured	No			110	Each	0.0000	2	2			
D3264-1 Bracket													
D3297-1-0121		Manufactured	No			110	Each	6.0000	1	1			
D3297-1-0121 Hose Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST209		6							
					115581	2							
					140748	4							

Picklist Print

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Work Order ID: 143790

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Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 3/23/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

D3297-1-0130

Manufactured No

110

Each

5.0000

1

1

D3297-1-0130

Hose Ass'y

**

DAS 6
9-89 BAS
27
9-89

Location

Loc Qty

Loc Code

ST209

5

137517

2

142183

3

D3297-3-0350

Manufactured No

110

Each

4.0000

1

1

D3297-3-0350

Hose Assembly

**

DAS 6
9-89 BAS
27
9-89

Location

Loc Qty

Loc Code

ST209

4

134299

1

142184

3

D3298-001

Manufactured No

110

Each

2.0000

1

1

D3298-001

Tube Assembly

**

DAS 6
9-89 BAS
27
9-89

Location

Loc Qty

Loc Code

ST210

2

120131

1

141408

1

D3298-009

Manufactured No

110

Each

3.0000

1

1

D3298-009

Tube Assembly

**

DAS 6
9-89 BAS
27
9-89

Location

Loc Qty

Loc Code

ST210

3

120492

1

141614

2

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Work Order ID: 143790

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Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 3/23/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

D3299-1

Manufactured No

110

Each

4.0000

1

1

D3299-1

Fitting

**

DAS 27
6 9-89DAS
28
9-89LocationLoc QtyLoc Code

ST030

4

103865

4

D3299-3

Manufactured No

110

Each

10.0000

1

1

D3299-3

Fitting

**

DAS 27
6 9-89DAS
28
9-89LocationLoc QtyLoc Code

ST030

10

103866

10

D3301-1

Manufactured No

110

Each

5.0000

1

1

D3301-1

Placard

**

DAS 27
6 9-89DAS
28
9-89LocationLoc QtyLoc Code

ST030

5

132029

5

D3301-3

Manufactured No

110

Each

4.0000

1

1

D3301-3

Placard

**

DAS 27
6 9-89DAS
28
9-89LocationLoc QtyLoc Code

ST030

4

137528

4

DAS 6
6 9-89

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Work Order ID: 143790

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Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 3/23/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

D3302-1

Manufactured No

110

Each

13.0000

1

1

D3302-1

Doubler

DAS
28
9-89

Location

Loc Qty

Loc Code

ST494

13

~~125877~~

1

137783

12

D3302-3

Manufactured No

110

Each

12.0000

1

1

D3302-3

Doubler

DAS
28
9-89

Location

Loc Qty

Loc Code

ST494

12

140808

12

AN3-5A

Purchased No

110

Each

416.0000

4

4

AN3-5A

Bolt

Location

Loc Qty

Loc Code

FP001

36

m133686

2

m134055

34

GA

14

m133686

14

ST350

366

m134055

66

m134502

300

DAS
28
9-89

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Work Order ID: 143790

143790

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 3/23/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

AN814-6D Purchased No

110

Each

6.0000

1

1

AN814-6D

Plug

DAS
28
9-89

Location

Loc Qty

Loc Code

ST326

6

m132677

2

m134405

4

**

DAS
6
9-89

DAS
27
9-89

AN815-6D Purchased No

110

Each

21.0000

2

2

AN815-6D

Union-M-Flare

DAS
28
9-89

Location

Loc Qty

Loc Code

ST326

21

m132680

21

**

DAS
6
9-89

DAS
27
9-89

AN833-6D Purchased No

110

Each

14.0000

3

3

AN833-6D

Elbow, Bulkhead-M-Flare

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK006

11

M130466

11

ST324

3

M130466

3

**

DAS
6
9-89

DAS
27
9-89

AN924-6D Purchased No

110

Each

49.0000

4

4

AN924-6D

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST322

49

m132680

10

m133938

15

m134502

24

**

DAS
6
9-89

DAS
27
9-89

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Page 6

Work Order ID: 143790

143790

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 3/23/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

110

Each

1,839.000

4

4

NAS1149D0332.J

Washer

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA	14	
m129682	14	
GA	110	
m132677	110	
ST260a	1600	
m133988	600	
m134502	1000	
ST266	115	
m133498	115	

NAS1149D0363J

Purchased

No

110

Each

1,710.000

8

8

NAS1149D0363.J

Washer

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	32	
m130799	32	
Return2016	2	
m132317	2	
ST263	1676	
m134055	676	
m134370	1000	

NAS1149D0963J

Purchased

No

110

Each

70.0000

2

2

NAS1149D0963.J

Washer

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

st268	70	
125445	70	

2

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Work Order ID: 143790

143790

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 3/23/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,490.000

4

4

MS21042L3

Nut

DAS 6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

838

m133790

38

m134360

800

OVER007

1200

m134360

1200

Return2016

1

M132382

1

ST304

351

m134039

351

MS21919-WDG12

Purchased

No

110

Each

37.0000

1

1

MS21919-WDG12

Clamp

DAS 6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST293

37

m129630

37

MS21919-WDG16

Purchased

No

110

Each

10.0000

2

2

MS21919-WDG16

Clamp

DAS 6 27
9-89 9-89
MAR 31 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

ST292

10

m128635

2

m133363

8

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Work Order ID: 143790

143790

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 3/23/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG9

Purchased

No

110

Each

100.0000

5

5

MS21919-WDG9

Clamp

DAS
28
9-89

Location

Loc Qty

Loc Code

ST293

100

m134376

100

MS21920-42

Purchased

No

110

Each

10.0000

2

2

MS21920-42

CLAMP

DAS
28
9-89

Location

Loc Qty

Loc Code

ST546

10

m132550

4

m134050

6

MS29512-06

Purchased

No

110

Each

31.0000

5

5

MS29512-06

O-RING

DAS
28
9-89

Location

Loc Qty

Loc Code

ST274

31

m132617

15

m132680

16

MS35489-11

Purchased

No

110

Each

17.0000

1

1

MS35489-11

GROMMET

DAS
28
9-89

Location

Loc Qty

Loc Code

ST269

17

m129499

17

DAS
6
9-89
BAS
27
9-89

DAS
6
9-89
BAS
27
9-89

DAS
6
9-89
BAS
27
9-89

DAS
6
9-89
BAS
27
9-89

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Work Order ID 143790

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143790

Accept

N900040100Setup Start ***NS1***
Stop ***NS2***

Item ID: D205-706-013

Revision ID:

Item Name: Fuel Purge Canister

Start Date: 3/23/2016 Start Qty: 1.00

Required Date: 4/1/2016 Req'd Qty: 1.00

1***1***

Cust Item ID:

Customer:

Reference:

Run Start ***NR1***
Stop ***NR2***

Approvals:

Process Plan: SIADate: 20160322 Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D412-706

B

0.00

100

Document Control

DOCUMENT CONTROL

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and create labels per PPP D205-706-013 CHG003

0.00

0.00

0.00

0.00

0.00

110

Pick Kit

110

Packaging

Packaging

Memo

QC4- 100% Inspect kits for completeness

120

120

QC

Quality Control

Memo

ML5 APR 01 2016MAR 31 2016

Qty -011	Qty -013	Qty -015	Part Number	Description
1			AN833-8D	ELBOW
		1	AN919-6D	REDUCER
4	4	1	AN924-6D	NUT
1			AN924-8D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER
2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
7	5	5	MS29512-06	O-RING (OR M83248/1-906)
3			MS29512-08	O-RING (OR M83248/1-908)
	1	1	MS35489-11	GROMMET
1			MS35489-16	GROMMET

DAS
28
9-88

REFERENCE ONLY

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214/EAGLE SINGLE)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
	1	1	D3262-041	CANISTER ASSEMBLY
1			D3262-043	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
1	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
	1		D3298-001	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1			D3299-7	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
1			D4054-001	TUBE ASSEMBLY
1			D4054-003	TUBE ASSEMBLY
1			D4054-009	TUBE ASSEMBLY
4	4	4	AN3-5A	BOLT
	1	1	AN814-6D	PLUG
1			AN814-8D	PLUG
2	2	2	AN815-6D	UNION
1			AN815-8D	UNION
		1	AN816-6D	NIPPLE
2	3	1	AN833-6D	ELBOW

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